

DNG



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBE350A94-2706-00-03A

Job Sheet 180109



Part No: RBE350A94-2706-00-03A

Job Qty: 60 ea

Part Name: Pin Shaft



Part Weight: 0 lbs

Status: At Planning

Priority: Medium

Job Created: 6/28/18

Job Tracking No:

Due Date: 7/23/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBE350A94-2706-00 REV 6 IPP REV A 18-01-15 NEW ISSUE JFC VERIFIED DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	60 Ea	7/23/18	7/23/18	0.00	0.00	Start Up Machining-3		JB 18-09-24
110	CNC Lathe	60 pcs	7/23/18	7/23/18	0.00	30.00	MORI SL-154		JB 18-09-24
120	QC	60 pcs	7/23/18	7/23/18	0.00	0.00	QC2 Machining-4		JB 18-09-24
130	QC	60 pcs	7/23/18	7/23/18	0.00	0.00	QC8 Machining-4		JB 18-09-24
140	Packaging	60 pcs	7/23/18	7/23/18	0.00	0.00	Packaging3-1		JB 18-09-24
150	QC21-SA	60 Ea	7/23/18	7/23/18	0.00	0.00	QC21		SEP 25 2018

Part Op 110 - 1-Machine as per DWG. FB735 FOLIO REV: _____ DWG REV: _____ 2-Deburr 3-Engrave Dash
Descriptions: number Using Marktronic engraver as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
88625K67	Dowel Pin Ø8mm x 40mm	60 ft (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	88625K67	60	36	0

Part Specifications

Specifications could not be found.



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
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Container No: S113133



Part: RBE350A94-2706-00-03A

Job No: 180109

Serial No/Batch: S113133

Revision: 6

Inspector:

Exp Date:

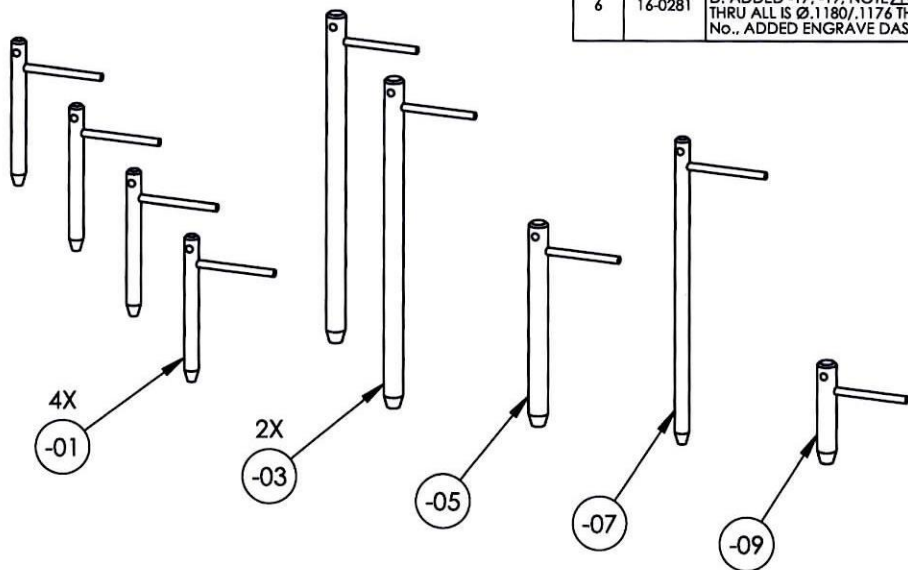
Instructions:

Date: 09/24/18

Plex 6/28/18 4:15 PM dart.logan.david

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		DESIGNED PER HELI PRODUCTS TOOLS.	9/11/2009	WP	DW
2		ADDED ONE MORE -03 PIN, FLAG AND CABLE TIE.	6/14/2010	WP	DW
3		MOVED LENGTH B DIMENSION TO Ø.118in. HOLE CENTERLINE & ADDED 1.5mm TO -01 THRU -09 PINS IN TABLE. ADDED A TOLERANCE TO Ø.118in HOLE TO ACHIEVE A LIGHT PRESS FIT FOR -11. CH'D HOLE FROM Ø.118 TO Ø.113 FOR CABLE TIES. END OF PIN PER S.E.	12/15/2010	RJC	RW
4		CORRECTED PIN VIEW SHEET 1 AND CH'D Ø.113 [Ø2.9mm] HOLE TO Ø.118 [Ø3.0mm] PER G.E.	5/9/2012	RJC	GE
4A		CH'D T/N WAS RBEA94-2706-00 IS RBE350A94-2706-00.	11/6/2013	RJC	RW
5	15-0120	UPDATED TO NEW DRAFTING STANDARDS. CH'D TOLERANCE BLOCK WAS .XXX ± .004 IS .XXX ± .005. ADDED P/N'S -01A, -03A, -05A, -07A, -09A. CH'D TOLERANCE ON NON-CRITICAL DIMENSIONS.	5/26/2015	DPD	JAG
6	16-0281	UPDATED TO DRAFTING STANDARD. -01, -03, -05, -07, -09 ADDED FINISH SPEC QSMI-6.2.2, B.O. REV D. ADDED -17, -19, NOTE A. -01A, -03A, -05A, -07A, -09A CH'D DIM WAS 2X Ø.118 ± .001/-0.000 THRU ALL IS Ø.1180/1.176 THRU ALL [P.F. -11]. ADDED DIM Ø.12 THRU ALL. ADDED ENGRAVE DASH No.. ADDED ENGRAVE DASH No. COLUMN TO TABLE.	1/12/2017	RJC	JAG



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WITHOUT NOTICE
WORK ORDER
NO. 130109
20180719

ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
				X		-01	4	PIN			2
				1		-01A		PIN SHAFT	O-1	Ø6mm X 3 FT (MCMASTER-CARR #88625K65) MODIFIED	3
			X			-03	2	PIN			2
			1			-03A		PIN SHAFT	O-1	Ø8mm X 3 FT (MCMASTER-CARR #88625K67) MODIFIED	3
		X				-05	1	PIN			2
		1				-05A		PIN SHAFT	O-1	Ø8mm X 3 FT (MCMASTER-CARR #88625K67) MODIFIED	3
	X					-07	1	PIN			2
	1					-07A		PIN SHAFT	O-1	Ø6mm X 3 FT (MCMASTER-CARR #88625K65) MODIFIED	3
X						-09	1	PIN			2
1						-09A		PIN SHAFT	O-1	Ø8mm X 3 FT (MCMASTER-CARR #88625K67) MODIFIED	3
1	1	1	1	1	B/O	-11		DOWEL PIN	STEEL	Ø3mm X 40mm (MCMASTER-CARR #91595A142)	2
					B/O	-13	1	RE-SEALABLE PLASTIC BAG		5 IN X 6 IN APPROX.	N/S
A/R	A/R	A/R	A/R	A/R	B/O	-15		LOCTITE 680			2
1	1	1	1	1	B/O	-17		FLAGS, REMOVE BEFORE FLIGHT	NYLON	NAS 1756-12	2
1	1	1	1	1	B/O	-19		CABLE TIE	BLACK NYLON	(MCMASTER-CARR #7189K31)	2
ASSY -09	ASSY -07	ASSY -05	ASSY -03	ASSY -01							

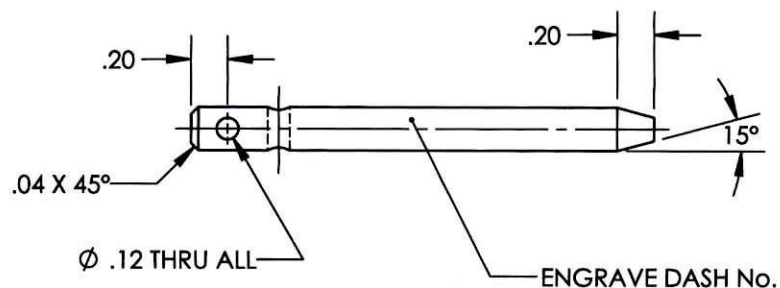
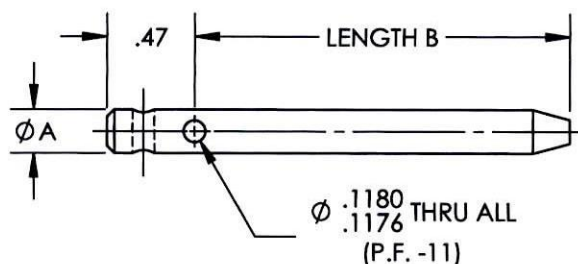
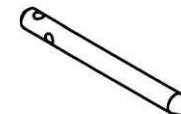
		TITLE	
		RIGGING PIN SET	
DWG NO.		REV	
RBE350A94-2706-00		6	
MAT'L HEAT TREAT FINISH SPEC		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 12.5	
DRAWN BY: PERRITT		1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
CHECKED: DUERFELDT		2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
OPPS APPR: ANDERSON		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
QA APPR: LINDSAY		USED ON MODEL	
APPROVED: GILBERT		EUROCOPTER AS350/355	
SCALE	1:3	DATE	9/11/2009
		SHEET 1 OF 3	

INSPECTION SHEET

Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

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4	15-0120	CH'D TOLERANCE BLOCK WAS .XXX ± .004 IS .XXX ± .005.	5/26/2015	DPD	JAG
6	16-0281	-01A, -03A, -05A, -07A, -09A CH'D DIM WAS 2X Ø.118 +.001/-.000 THRU ALL IS Ø.1180/.1176 THRU ALL (P.F. -11). ADDED DIM Ø.12 THRU ALL. ADDED ENGRAVE DASH No., ADDED ENGRAVE DASH No. COLUMN TO TABLE.	1/12/2017	RJC	JAG



(-01A, -03A, -05A, -07A, -09A)

PIN SHAFT

ENGRAVE	PIN DIMENSION TABLE		
DASH No.	P/N	ØA	LENGTH B
-01	-01A	6mm	2.028
-03	-03A	8mm	5.177
-05	-05A	8mm	3.012
-07	-07A	6mm	4.783
-09	-09A	8mm	1.240

			
TITLE			
RIGGING PIN SET			
DWG NO.			REV
RBE350A94-2706-00-01A			6
MAT'L O-1		UNLESS OTHERWISE SPECIFIED	
HEAT TREAT		DIMENSIONS ARE IN INCHES	
FINISH SEE -01, -03, -05, -07, -09		.XXX ± .005 FRACTIONS AS IN CHES .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125√	
SPEC		1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
DRAWN BY:	PERRITT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
CHECKED:	DUERFELDT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
OPPS APPR:	ANDERSON	USED ON MODEL	
QA APPR:	LINDSAY	EUROCOPTER AS350/355	
APPROVED:	GILBERT		
SCALE	1:1	DATE	9/11/2009
		SHEET 3 OF 3	